Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

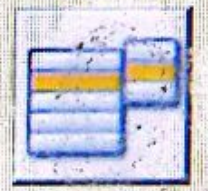
Early settings
Only for expert users!!!

Machine configuration Wizard

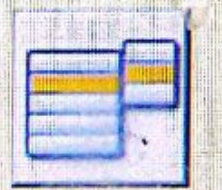
Set Main Line data

Driving code control removal

Update Sinamics firmware



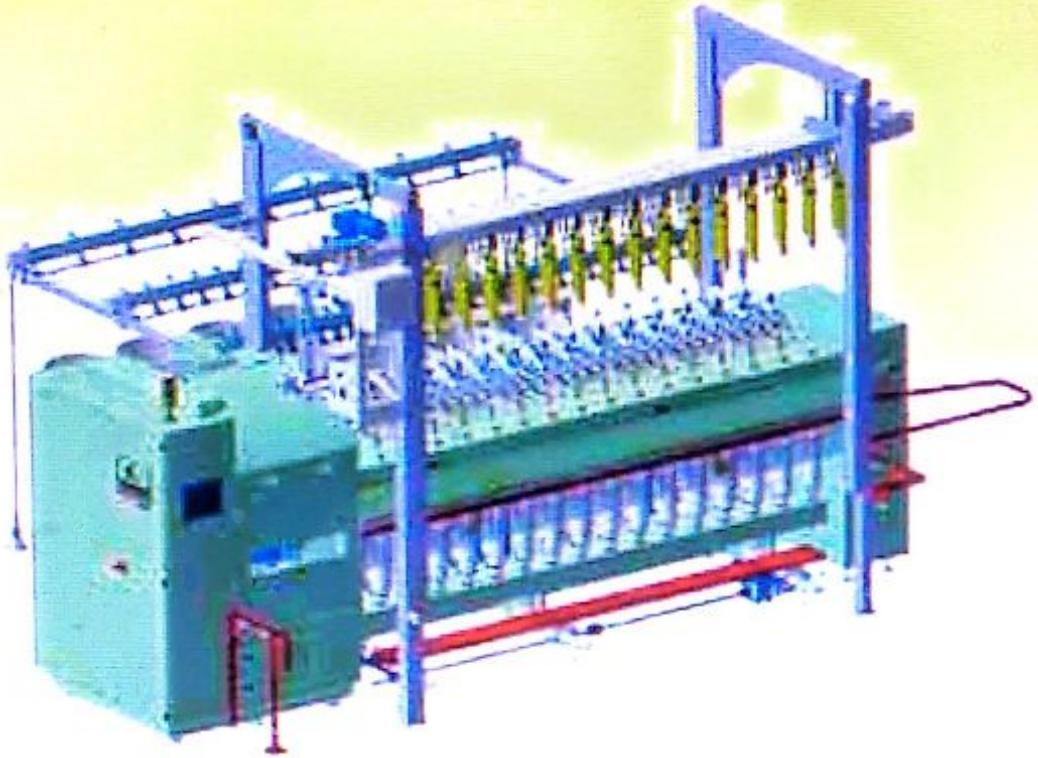
Writing / Reading sinamics parameters



Writing / Reading motors parameters

Shift
Day
Lot
Totals
Efficiencies
Stops

CONFIGURATION WIZARD



In use

Insert the number of the sinamics configuration:

2 [40KW]

2 [40KW]

Confirm
Data loading

Continue Wizard

Unload
Doffing
Roving f.

127 - MOTORS DATA LOADING WIZARD

Wizard.

127

9:50:59 AM
08/06/2026

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

		In use
Input the power spindles drive motors:	18KW [n.6]	18KW [n.6]
Input the power flyers drive motors:	11KW	11KW

Confirm
Data loading

Save
Ram to Rom
(3 sec.)

Continue Wizard

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

Update Sinamics firmware.

Push the botton to start Sinamics firmware update.
When upgrade is done it will be necessary to restart the system.

0 %

Continue Wizard

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

Driving code control removal

Push the botton to remove drives code checking.
Execute a Ram to Rom copy when procedure is done
to preserve data when machine will be turned off.

Remove
control

Save
Ram to Rom
(3 sec.)

Continue Wizard

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

Set Main Line data

Execute this procedure with Main Line turned off.
Insert Line voltage and frequency then push the button to acquire new data.
Insert Main Line only when requested.

Line Voltage: 380.0 VAC

Line frequency: 50 HZ

Fast shutdown for black-out Voltage trigger: 460.0 VDC

Acquire new data

Save Ram to Rom (3 sec.)

Continue Wizard

Doffing
Roving f.

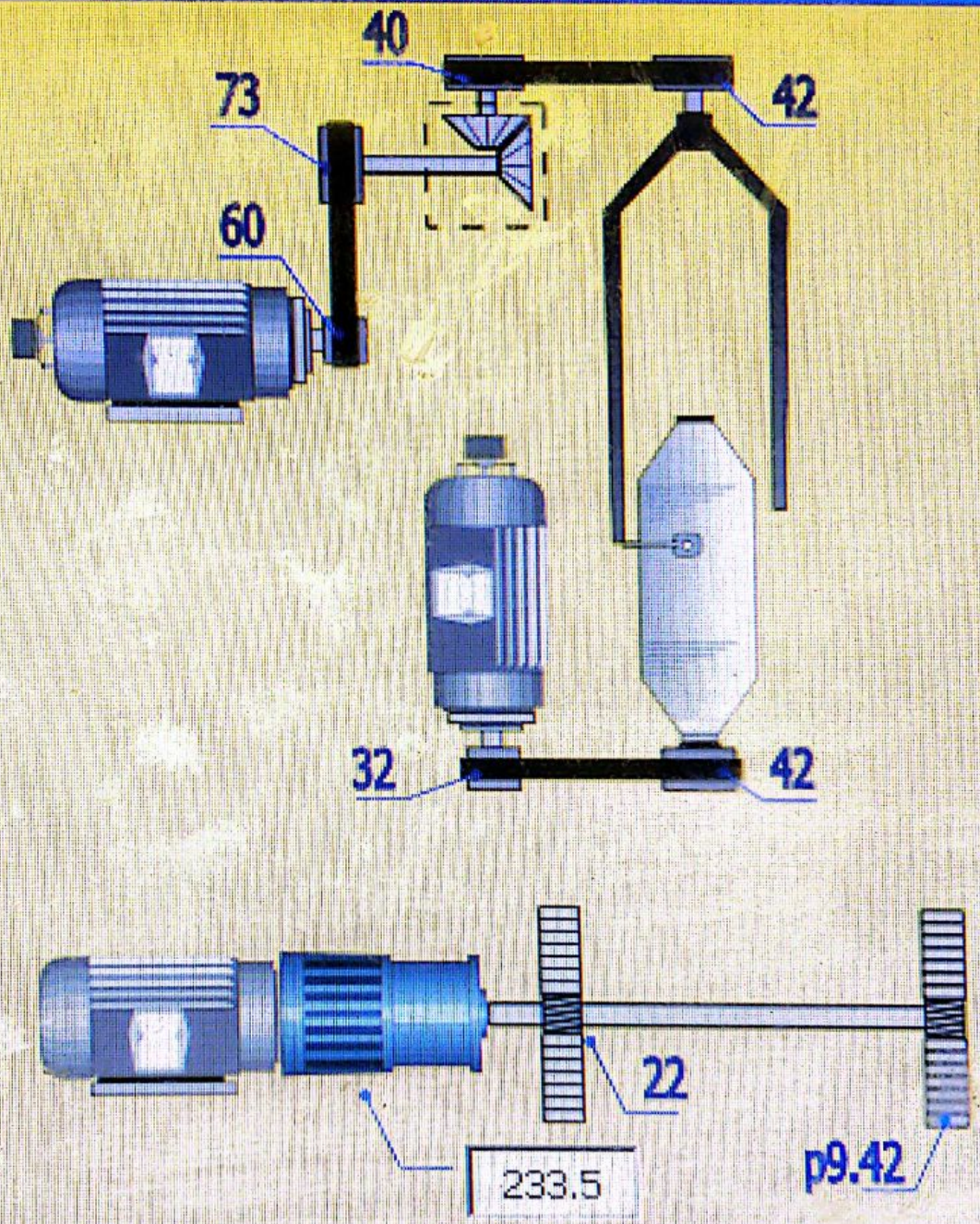
112 - KINEMATIS 1 WIZARD

Wizard.

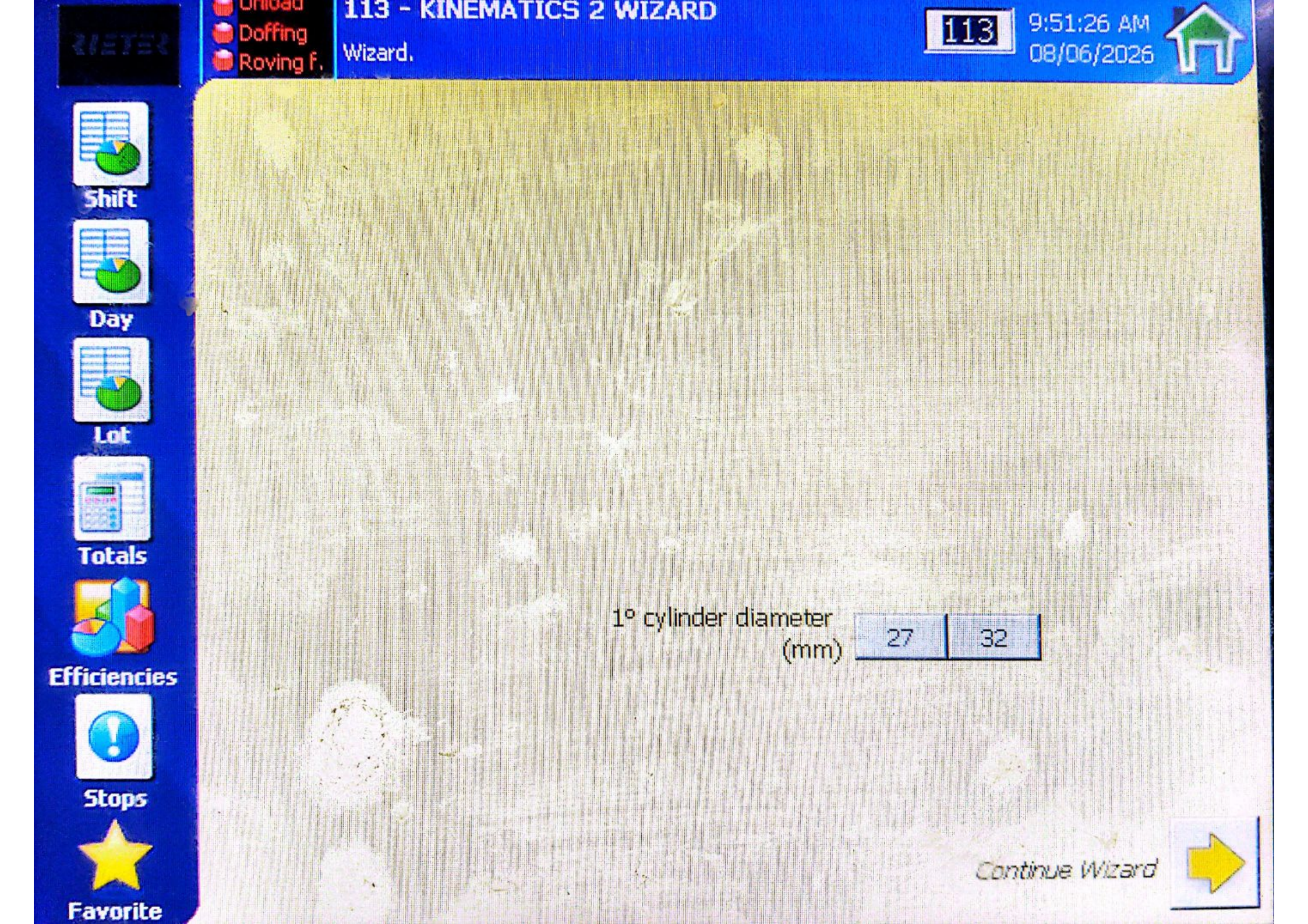
112

9:51:20 AM
08/06/2026

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite



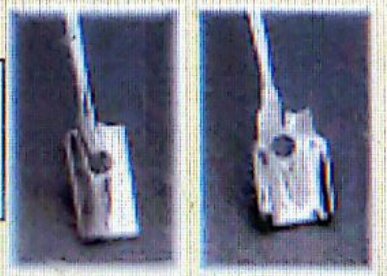
Continue Wizard


Unload
Doffing
Roving f.
113 - KINEMATICS 2 WIZARD
Wizard.
113
9:51:26 AM
08/06/2026
Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite
1° cylinder diameter (mm)
27
32
Continue Wizard

Shift
Day
Lot
Totals
ficiencies
Stops
Favorite

Brand	:	☐ Marzoli	☑ Rieter	
Model	:	☑ FT6	☐ FT7	
Flyer type	:	☑ 6" (152,4mm)		
Spindles number	:	192		
Suction	:	☐ Included		
Blower	:	☑ Included		
Reserve type	:	☐ Low	☐ Center	☑ High
Roving control	:	☑ Roj	☐ Marzoli RTS	☐ Marzoli R2S

Compressor suitable with selected reserve



Continue Wizard

Shift
Day
Lot
Totals
ficiencies
Stops
Favorite

Autodoffing	:	☑ Included	● Ready module	
Bobbins transport type	:	☑ Trains	☐ Monorail	☐ Manual
Transport gauge	:	☐ <=180mm	☑ >=220mm	
Trains	:	☑ Utit	☐ Schönenb.	

Push the botton to remove drives code checking.
Execute a Ram to Rom copy when procedure is done
to preserve data when machine will be tourned off.

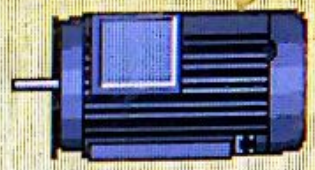
Save
Ram to Rom
(3 sec.)

Wizard end

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

Selected motor:

Flyers



Parameters list:

400.00	P304 - Nominal Voltage
21.00	P305 - Nominal Current
11.00	P307 - Nominal Power
0.85	P308 - Cos Phi
50.00	P310 - Nominal Frequency
1477.00	P311 - Nominal speed
2000.00	P322 - Maximum speed
2000.00	P2000 - Maximum speed
15.00	P1460 - Gain
5.00	P1462 - Integrative time

Reading

Writing

Save
Ram to Rom
(3 sec.)

Unload
Doffing
Roving f.

129 - PARAMETERS MOTORI

Wizard.

129

9:52:09 AM
08/06/2026

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

Selected motor:

Spindles

ATTENTION!!
THE PARAMETERS 305 AND 307
MUST TO BE TAKE IN
CONSIDERATION OR CALCULATION AS
A EQUIVALENT AND
UNIQUE SPINDLES MOTOR

Parameters list:

400.00	P304 - Nominal Voltage
30.60	P305 - Nominal Current
18.00	P307 - Nominal Power
0.85	P308 - Cos Phi
50.00	P310 - Nominal Frequency
1455.00	P311 - Nominal speed
3000.00	P322 - Maximum speed
3000.00	P2000 - Maximum speed
15.00	P1460 - Gain
10.00	P1462 - Integrative time

Reading

Writing

Save
Ram to Rom
(3 sec.)

Unload
Doffing
Roving f.

129 - PARAMETERS MOTORI

Wizard.

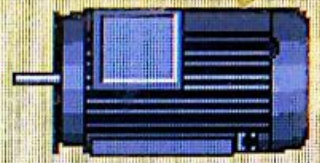
129

9:52:16 AM
08/06/2026

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

Selected motor:

D.Rollers



Parameters list:

400.00	P304 - Nominal Voltage
8.30	P305 - Nominal Current
4.00	P307 - Nominal Power
0.83	P308 - Cos Phi
50.00	P310 - Nominal Frequency
1440.00	P311 - Nominal speed
2000.00	P322 - Maximum speed
2000.00	P2000 - Maximum speed
4.50	P1460 - Gain
10.00	P1462 - Integrative time

Reading

Writing

Save
Ram to Rom
(3 sec.)

Unload
Doffing
Roving f.

129 - PARAMETERS MOTORI

Wizard.

129

9:52:23 AM
08/06/2026

Shift

Day

Lot

Totals

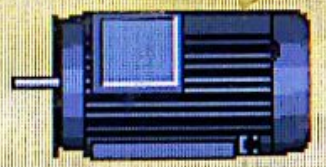
Efficiencies

Stops

Favorite

Selected motor:

Rail



Parameters list:

325.00	P304 - Nominal Voltage
8.00	P305 - Nominal Current
3.75	P307 - Nominal Power
0.00	P308 - Cos Phi
0.00	P310 - Nominal Frequency
3000.00	P311 - Nominal speed
5000.00	P322 - Maximum speed
3000.00	P2000 - Maximum speed
1.49	P1460 - Gain
10.00	P1462 - Integrative time

Reading

Writing

Save
Ram to Rom
(3 sec.)

Unload
Doffing
Roving f.

129 - PARAMETERS MOTORI

Wizard.

129

9:52:29 AM
08/06/2026

Shift

Day

Lot

Totals

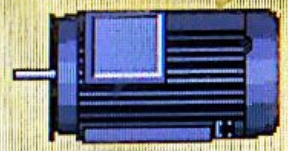
Efficiencies

Stops

Favorite

Selected motor:

Creel



Parameters list:

400.00	P304 - Nominal Voltage
3.80	P305 - Nominal Current
1.50	P307 - Nominal Power
0.81	P308 - Cos Phi
50.00	P310 - Nominal Frequency
1390.00	P311 - Nominal speed
2000.00	P322 - Maximum speed
3000.00	P2000 - Maximum speed
1.15	P1460 - Gain
10.00	P1462 - Integrative time

Reading

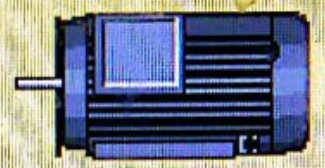
Writing

Save
Ram to Rom
(3 sec.)

Shift
Day
Lot
Totals
Efficiencies
Stops
Favorite

Selected motor:

Belt



Parameters list:

400.00	P304 - Nominal Voltage
0.81	P305 - Nominal Current
0.25	P307 - Nominal Power
0.76	P308 - Cos Phi
50.00	P310 - Nominal Frequency
890.00	P311 - Nominal speed
2000.00	P322 - Maximum speed
2000.00	P2000 - Maximum speed
0.21	P1460 - Gain
10.00	P1462 - Integrative time

Reading

Writing

Save
Ram to Rom
(3 sec.)

Unload
Doffing
Roving f.

124 - SINAMICS PARAMETERS

Wizard.

124

9:52:56 AM
08/06/2026

Shift

Day

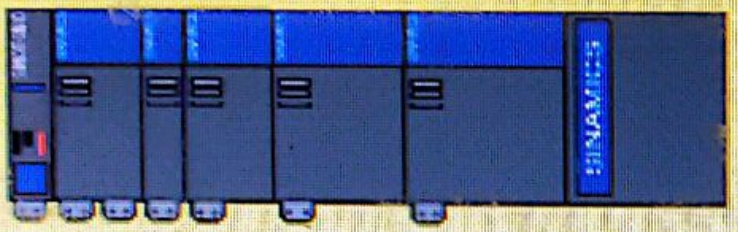
Lot

Totals

Efficiencies

Stops

Favorite



Sinamics device:

Flyers

Parameter number: 1441 0

Value: 0.00

Double value:

Reading

Writing

Save
Ram to Rom
(3 sec.)

Unload
Dofting
Roving f.

124 - SINAMICS PARAMETERS

Wizard.

124

9:53:01 AM
08/06/2026

Shift

Day

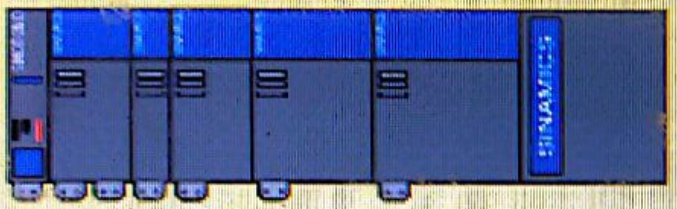
Lot

Totals

Efficiencies

Stops

Favorite



Sinamics device:

Spindles

Parameter number: 1441 0

Value: 0.00

Double value:

Reading

Writing

Save
Ram to Rom
(3 sec.)

Unload
Doffing
Roving f.

124 - SINAMICS PARAMETERS

Wizard.

124

9:53:01 AM
08/06/2026

Shift

Day

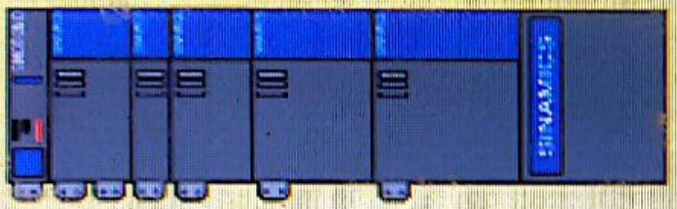
Lot

Totals

Efficiencies

Stops

Favorite



Sinamics device:

Spindles

Parameter number: 1441 0

Value: 0.00

Double value:

Reading

Writing

Save
Ram to Rom
(3 sec.)

For sensor "6"

Unload
Doffing
Roving f.

124 - SINAMICS PARAMETERS

Wizard.

124

9:53:09 AM
08/06/2026

Shift

Day

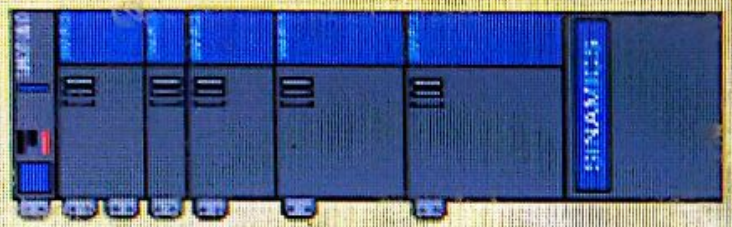
Lot

Totals

Efficiencies

Stops

Favorite



Sinamics device:

Rail

Reading

Writing

Parameter number: 1441 0

Value: 0.48

Double value:

Save
Ram to Rom
(3 sec.)

Machine sett.
Building
Building
Reserve
Single sensors
Tension ctrl. sensors
Favorite

Mode Start machine cycle					
Re-start	Manual :	☑	Automatic :	☐	
Reattachment	Manual :	☐	Automatic :	☑	
Building	Manual :	☐	Automatic :	☑	
Reserve	Manual :	☐	Automatic :	☑	
Mode Start doffing cycle					
Doffing	Manual :	☐	Automatic :	☑	Creel enabled: ☑
Unload	Manual :	☐	Automatic :	☑	

Controls insertion				
Anti-fluttering Bobbins	:	☐		
Pendulum arms pressure	:	☑		
Roving control	Singles :	☑	Arrow :	☑

Machine sett.
Building
Building
Reserve
Single sensors
Tension ctrl. sensors
Favorite

CCD1

Enabling sensor

0 1

0

Immediate value

5060

Tightened value

Acquire

CCD2

Enabling sensor

0 1

12656

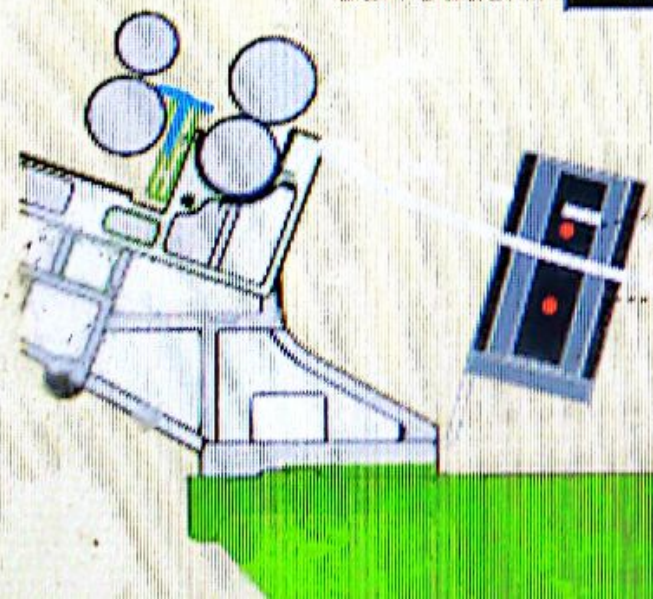
Immediate value

5075

Tightened value

Acquire

Correction: --- 5 --------

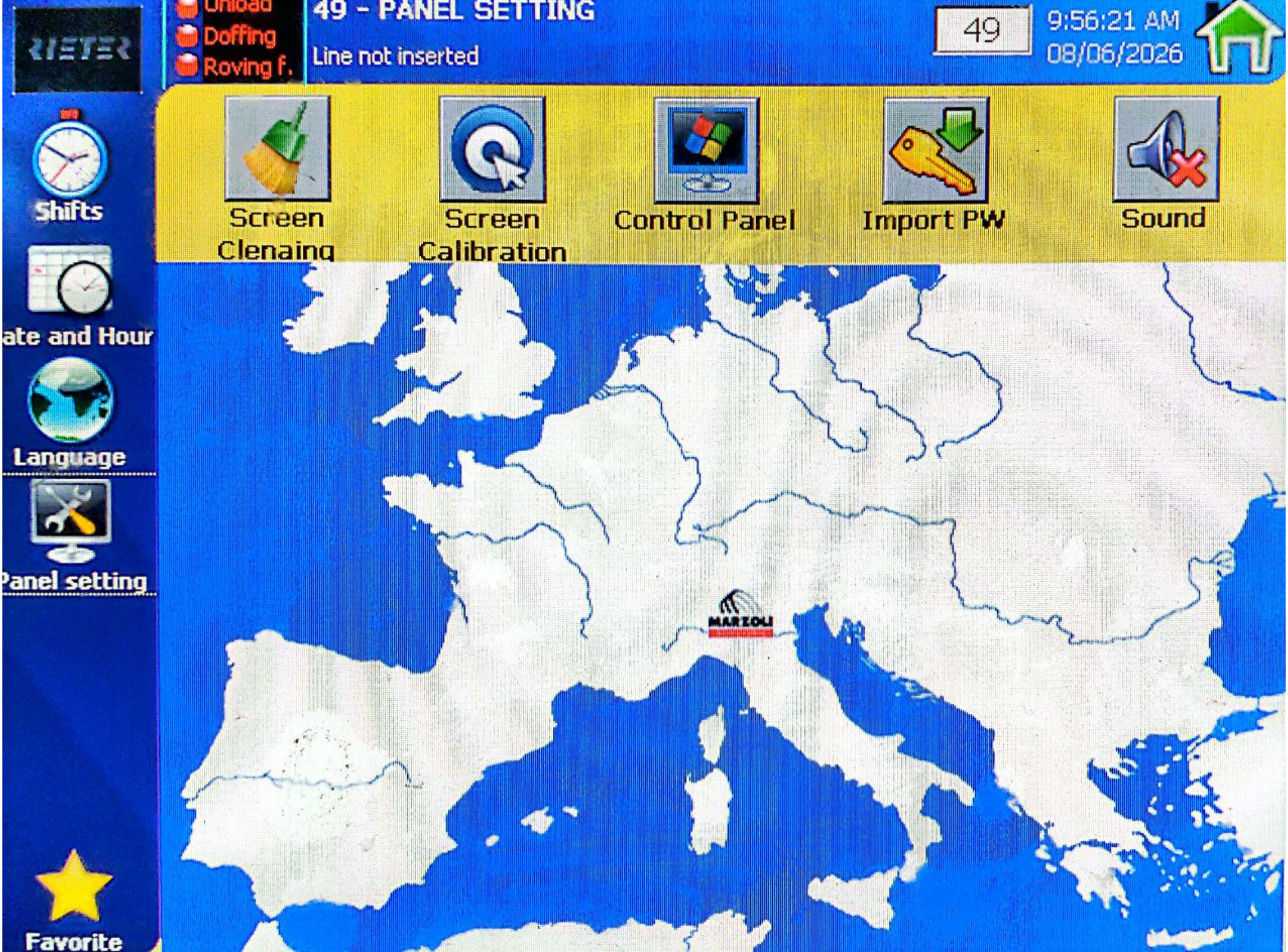


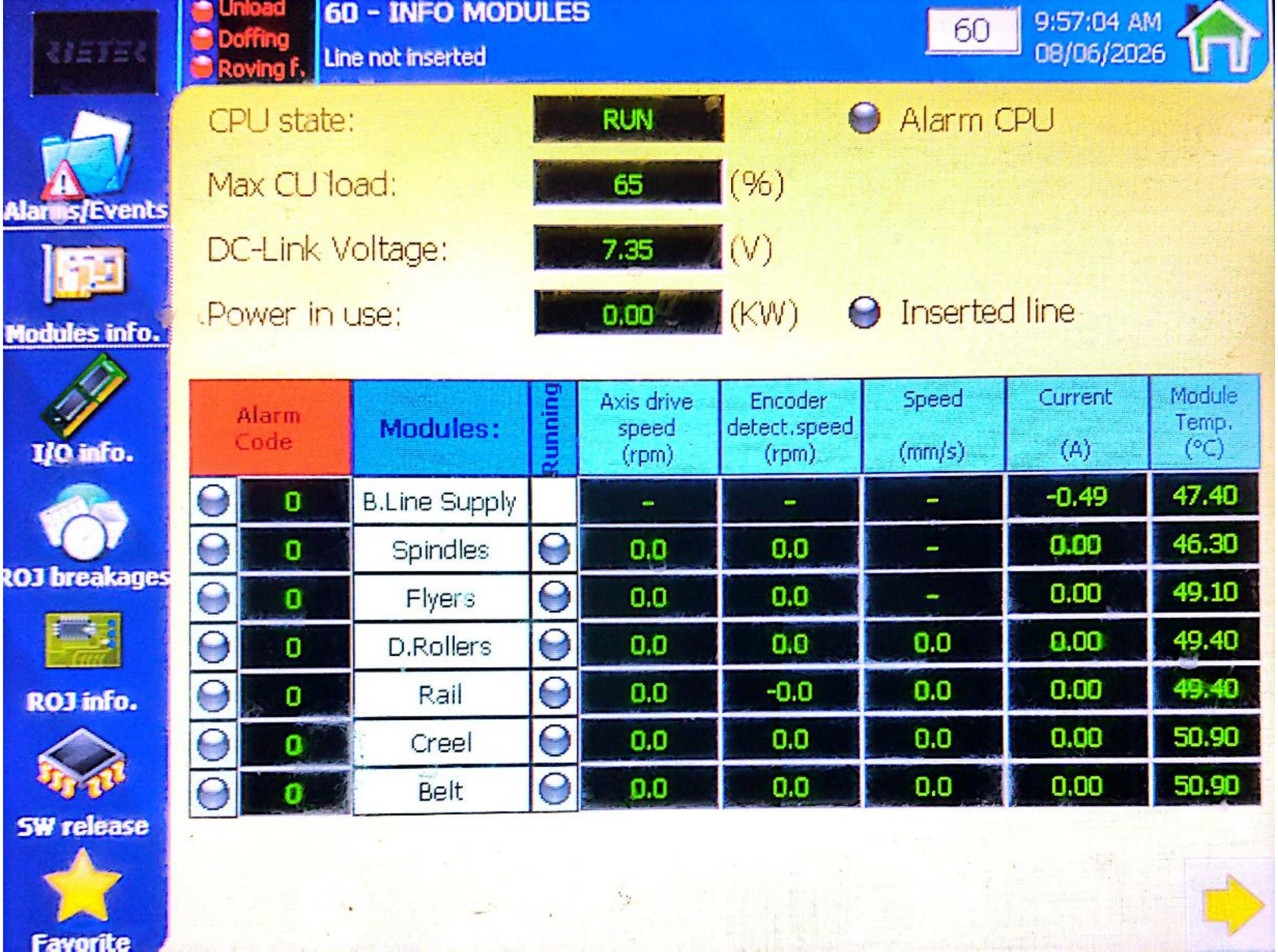
300 Top offset

Work area

700 Bottom offset

Card Info


RIETER
Unload
Doffing
Roving f.
49 - PANEL SETTING
Line not inserted
49
9:56:21 AM
08/06/2026
Shifts
Screen Clenaing
Screen Calibration
Control Panel
Import PW
Sound
ate and Hour
Language
Panel setting
MARZOLI
Favorite



Alarm Code	Modules:	Running	Axis drive speed (rpm)	Encoder detect.speed (rpm)	Speed (mm/s)	Current (A)	Module Temp. (°C)
0	B.Line Supply		-	-	-	-0.49	47.40
0	Spindles		0.0	0.0	-	0.00	46.30
0	Flyers		0.0	0.0	-	0.00	49.10
0	D.Rollers		0.0	0.0	0.0	0.00	49.40
0	Rail		0.0	-0.0	0.0	0.00	49.40
0	Creel		0.0	0.0	0.0	0.00	50.90
0	Belt		0.0	0.0	0.0	0.00	50.90

Unload
Doffing
Roving f.

61 - DIAGNOSTICS I/O MACHINE

Line not inserted

61

9:57:11 AM
08/06/2026

Alarms/Events

Modules info.

I/O info.

ROJ breakages

ROJ info.

SW release

Favorite

DIGITAL INPUT ET200S ROVING FRAME

U210.3	E60_Y35	1
	E60_Y37	5
	SE62.4	2
	SE62.3	6
U210.4	QF_X	1
	QF4.4	5
	ST218.1	2
	KM60.1	6
U210.5	SB62.1	1
	SB1	5
	SB2	2
	SB3	6
U210.6	SP220.1	1
	SE220.2	5
	SF220.3	2
	SF220.4	6
U210.7	SB60.1	1
	SF62_2	5
	SQ220.7	2
		6

U210.8	SF222.1	1
	EU237.1	5
	BF223.1B	2
	BF224.1	6
U210.09	BF224.2	1
	BF223.2	5
	BF223.3	2
	BF223.4	6

DIGITAL OUTPUT ET200S ROVING FRAME

U210.10	KA230.1	1
	KA230.2	5
	KA230.3	2
	HL230.1A	6
U210.11	HL230.1R	1
	HL230.1V	5
	HL230.7	2
	HL230.8	6
U210.12	Roj_IN1	1
	Roj_IN2	5
	KA232.3	2
	SPW_4	6
U210.13	SPW_5	1
	SPW_6	5
	SPW_7	2
	SPW_8	6
U210.14	SPW_9	1
	SPW_10	5
	SPW_11	2
	SPW_12	6

U210.15	KA235.1	1
	KA235.2	5
		2
		6

Spiderweb

Doffing
Roving f.

62 - DIAGNOSTICS I/O DOFFING A1

Line not inserted

62

9:57:17 AM
08/06/2026

Alarms/Events

Modules info.

I/O info.

ROJ breakages

ROJ info.

SW release

Favorite

DIGITAL INPUT
D425 X122-X132 DOFF

X122		
KM250.1	1	
KM250.2	2	
BF252.1	3	
BF252.2	4	
SQ244.6	7	
SQ244.7	8	
SQ244.8	10	
SQ244.9	11	

X132		
T_OK	1	
T_ALL	2	
T_CON	3	
BF254.2	4	

DIGITAL OUTPUT
D425 X132 DOFF

X132		
KA250.1	7	
KA250.2	8	
KA250.3	10	
KA250.4	11	

Unload
Doffing
Roving f.

63 - DIAGNOSTICS I/O DOFFING B1

Line not inserted

63

9:57:21 AM
08/06/2026

Alarms/Events

Modules info.

I/O info.

ROJ breakages

ROJ info.

SW release

Favorite

DIGITAL INPUT SOL.VALVE EXTENSION

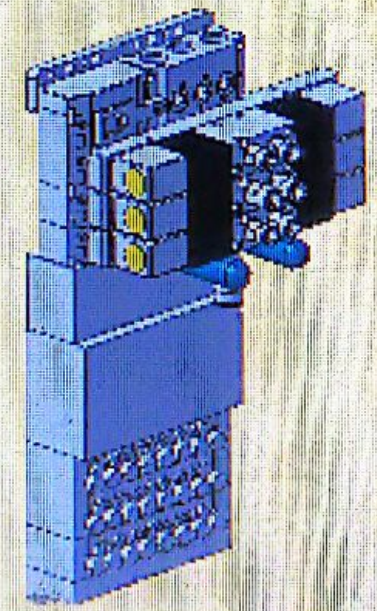
U10.1		
SE13.1	1	
SE13.2	2	
SE13.3	3	
SE13.4	4	
SE13.5	5	
SE13.6	6	
BF13.7	7	
BF13.8	8	

U10.2		
SE15.1	1	
SE15.2	2	
BF15.3	3	
BF15.4	4	
BF15.5	5	
SF15.6	6	
SF15.7	7	
SF15.8	8	

U10.3		
SQ17.1	1	
SQ17.2	2	
SQ17.3	3	
SQ17.4	4	
BF19.1A	5	
BF19.1B	6	
BF19.2A	7	
BF19.2B	8	

DIGITAL OUTPUT SOL.VALVE EXT.

YV22.1	YV22.3	YV22.5
YV22.2	YV22.4	YV22.6



Unload
Doffing
Roving f.

5 - INFO ROJ DEVICE

Line not inserted

5

9:57:44 AM
08/06/2026

Alarms/Events

Modules info.

I/O info.

ROJ breakages

ROJ info.

SW release

Favorite

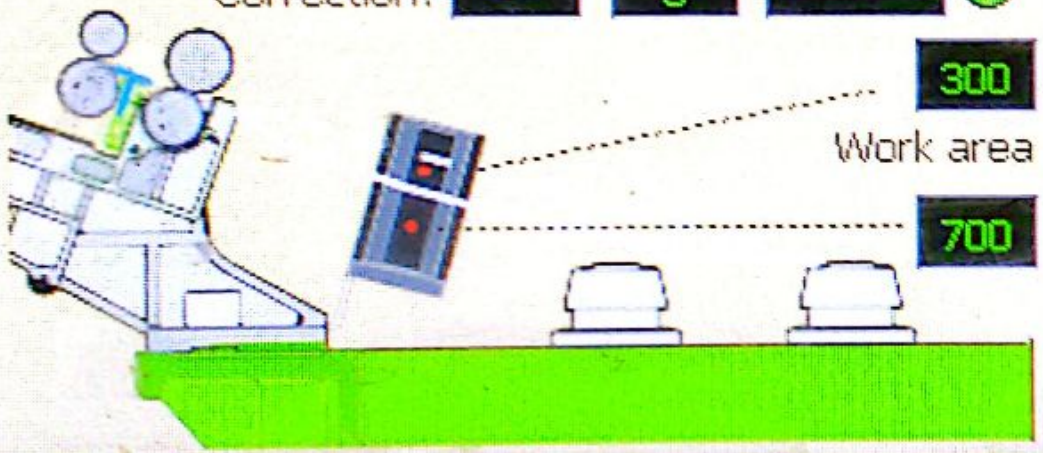
ROJ ROVING CONTROL BOARD

Single sensors	Included	0.09	SW release
Sensibility	1	187	Broken roving n°
Delay filter	300 ms	192	Detected roving n°
		0	Roj error

Alarm
Inibit.
run

			Immediate	Acquired	Average
Tension control	:	Included			
Sensor CCD1	:	Enabled	0	5060	5863
Sensor CCD2	:	Enabled	12655	5075	6091

Correction: --- 5 ---------

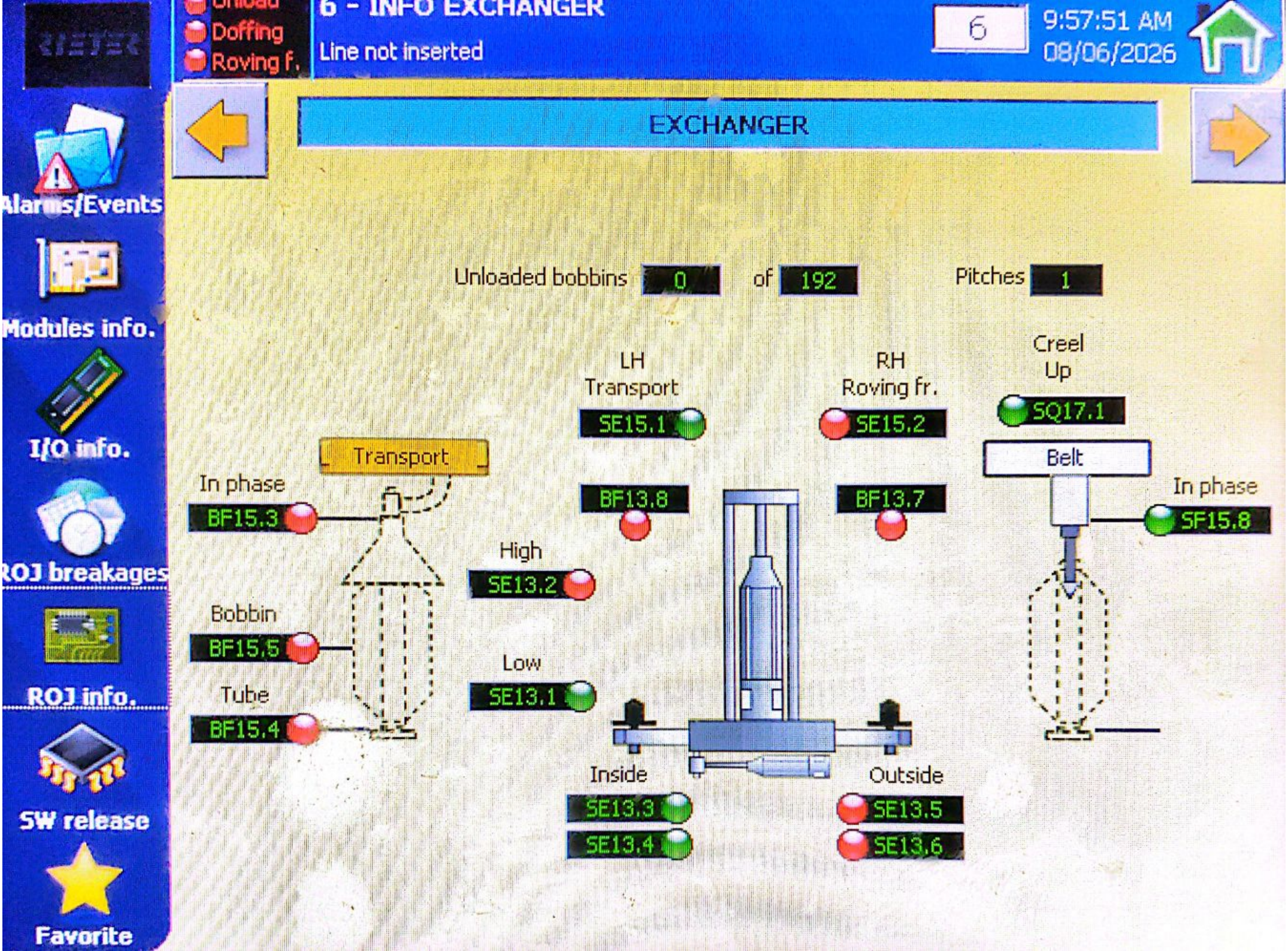


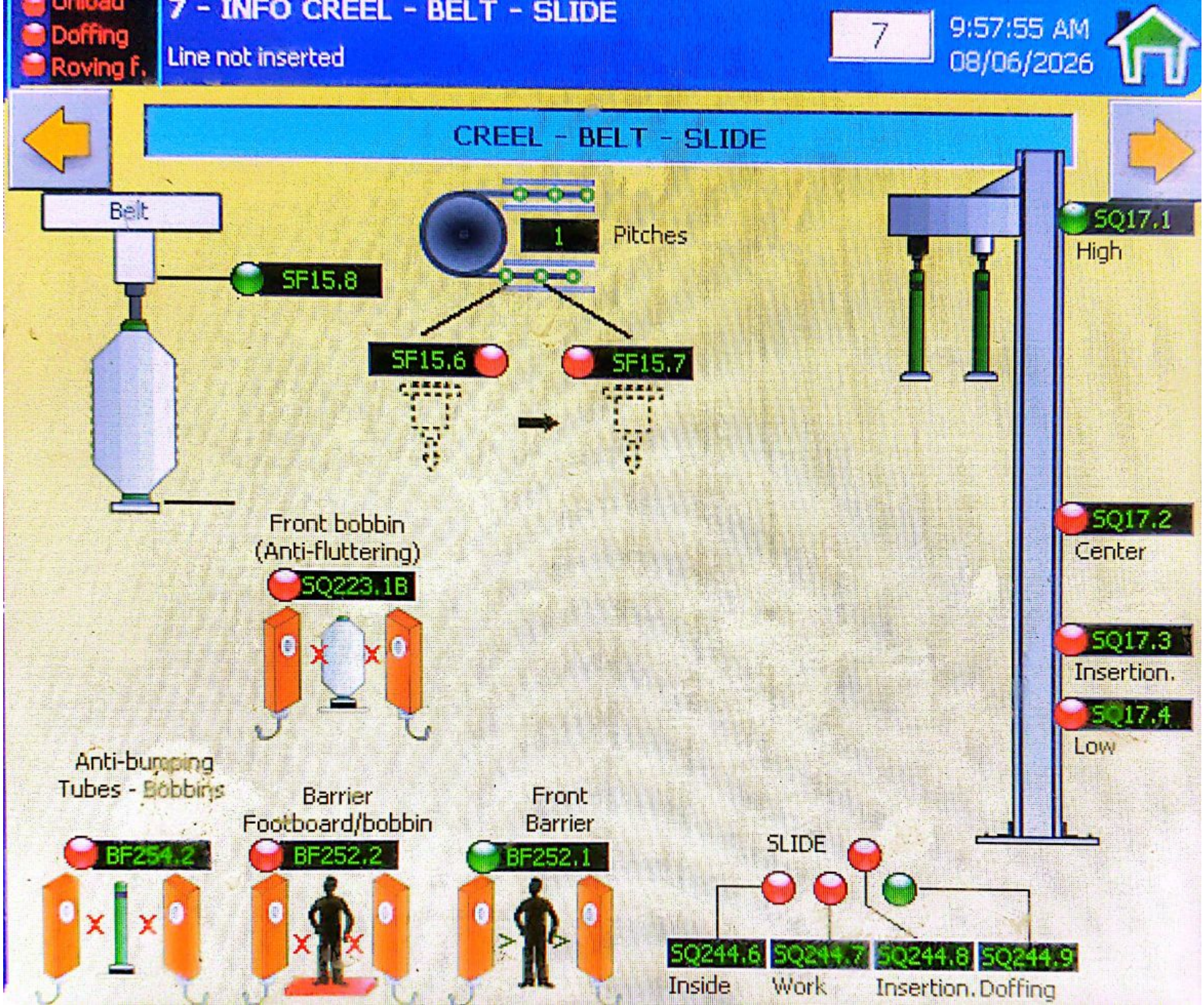
300 Top offset

Work area

700 Bottom offset

Roj card diagnosis


Alarms/Events
Modules info.
I/O info.
ROJ breakages
ROJ info.
SW release
Favorite
Unload
Doffing
Roving f.
6 - INFO EXCHANGER
Line not inserted
6
9:57:51 AM
08/06/2026
EXCHANGER
Unloaded bobbins 0
of 192
Pitches 1
LH
Transport
SE15.1
RH
Roving fr.
SE15.2
Creel
Up
SQ17.1
Transport
In phase
BF15.3
BF13.8
BF13.7
Belt
In phase
SF15.8
High
SE13.2
Bobbin
BF15.5
Low
SE13.1
Tube
BF15.4
Inside
SE13.3
SE13.4
Outside
SE13.5
SE13.6


Unload
Doffing
Roving f.
7 - INFO CREEL - BELT - SLIDE
Line not inserted
7
9:57:55 AM
08/06/2026
CREEL - BELT - SLIDE
Belt
SF15.8
1
Pitches
SF15.6
SF15.7
SQ17.1
High
SQ17.2
Center
SQ17.3
Insertion.
SQ17.4
Low
Front bobbin
(Anti-fluttering)
SQ223.1B
Anti-bumping
Tubes - Bobbins
BF254.2
Barrier
Footboard/bobbin
BF252.2
Front
Barrier
BF252.1
SLIDE
SQ244.6
SQ244.7
SQ244.8
SQ244.9
Inside
Work
Insertion.
Doffing

Roving f.

31 - TIMES

Line not inserted

31

9:58:08 AM
08/06/2026

Alarms/Events

Modules info.

I/O info.

ROJ breakages

ROJ info.

SW release

Favorite

Ramp times					
(0-2000 rpm)	Acceleration : (s)	35.000	Emergency : (s)	15.000
	Deceleration : (s)	30.000	Black Out : (s)	10.000

Auxiliary times		
Pendulum arms pressure-up duration	: (s)	10.000
Roving reattachment duration	: (s)	1.000
Delay for virtual cam increase at reversal	: (s)	0.100

Suction		
Running delay	: (s)	20.000

Blower		
Running delay	: (s)	30.000

Exchanger		
Rising delay for tubes ripple attenuation	: (s)	1.000

Alarms/Events
Modules info.
I/O info.
ROJ breakages
ROJ info.
SW release
Favorite

Inpulse formation speed		
Black button	(rpm)	15
Green button	(rpm)	250

Doffing motors speed					
Creel	Min. (mm/s)	45	Max. (mm/s)	75
Belt	Min. (mm/s)	55	Max. (mm/s)	75